

Split

Work Order ID 79377
Wednesday, January 25, 2012 11:50:02 AM

79377

ID: D4434-043
Description ID:
Name: Fwd inboard Bracket Assembly

Accept

N9000040100

Setup Start *NSS1*
Stop *NSS2*

Start Date: 1/25/2012 Start Qty: 1.00 *1*
Required Date: 2/3/2012 Req'd Qty: 1.00 *1*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: 12-01-25 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Inspection Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	---------------------

Draw Nbr	Revision Nbr
4434	A

00*
Waterjet
WCNC Waterjet
361.040
FLOW WATER JET
Memo
1-Cut D4434-1 as per Dwg
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

12-1-26

10*
Quality Control
QC2- Inspect parts off machine FAI/FAIB
Memo

12-1-26

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID- 79377***79377***

Page 2

Wednesday, January 25, 2012 11:50:02 AM

Item ID: D4434-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Stop ***NS2***

Start Date: 1/25/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

1- Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID -79377***79377***

Page 3

Wednesday, January 25, 2012 11:50:02 AM

Item ID: D4434-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

2 1/2 12-1-30

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

2 1/2 12-1-30

180

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg, do not install grommets and rubber seal.

2 1/2 12/01/30 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79377

79377

Page 4

Wednesday, January 25, 2012 11:50:03 AM

Item ID: D4434-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd inboard Bracket Assembly
 Start Date: 1/25/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	QC5- Inspect part completeness to step on W/O	0.00							
185									
QC	Memo	0.00							
Quality Control									
190	Black Sandtex(Ref:4.3.5.7) per QS1005 4.3	0.00							
190									
Powdercoat	Memo	0.00							
Powder Coating									
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.00							
Quality Control									

826170

Start Time: 9:30
 Temp: 3200F
 Finish Time: 10:00

2X Ø M-L 12/01/31

M115128

1 BL 12-1-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79377

January-31-12 12:29:38 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/25/12 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 2/03/12 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

202

0.00

Small Fab

Memo

Small Fab

Install rubber seals and grommets.

3M 1300 batch: 1120225

0.00

205

0.00

QC

Memo

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: GA 0.00

210

0.00

Packaging

Memo

Packaging

Work Order ID 79377

79377

Page 6

Wednesday, January 25, 2012 11:50:03 AM

Item ID: D4434-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd inboard Bracket Assembly
 Start Date: 1/25/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 1.00 *1* Customer:

Reference: Run Start *NR1*
 Approvals: Process Plan: Date: Tooling: Date: Stop *NR2*
 QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/2/11
 ME
 12-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 25, 2012 11:50:07 AM

Page 1

Work Order ID: 79377

79377

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24
per REV.A DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

330.9100

2.5

2.631579

**

M6061T6S 040

6061-T6 .040 Sheet

12-1-2

Location

Loc Qty

Loc Code

MAT021

330.91

113004

2.5

117653

40.91

120154

95.5

120218

192

120219

D4434-9

Manufactured

No

180

Each

0.0000

1

1

**

D4434-9

Bracket

B 79508

12/01/31

D4435-041

Manufactured

No

180

Each

0.0000

1

1

**

D4435-041

Bracket Assembly

B 79371

12/01/31

D4441-1

Manufactured

No

202

f

35.4840

0.142

0.142

**

D4441-1

Rubber Seal

12/01/31

Location

Loc Qty

Loc Code

prelim

35.484

74760

35.484

11/2

Cut qty 1 to 1.7"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, January 25, 2012 11:50:07 AM

Work Order ID: 79377

79377

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

D4441-1 Manufactured No

f 35.4840 0.208

D4441-1

**

SB 12/6/31

Rubber Seal

Location	Loc Qty	Loc Code
prelim	35.484	
74760	35.484	

1.208

Cut qty 1 to 2.5"

D4441-1 Manufactured No

f 35.4840 1.875

D4441-1

**

SB 12/6/31

Rubber Seal

Location	Loc Qty	Loc Code
prelim	35.484	
74760	35.484	

1.875

Cut qty 1 to 22.5"

D4440-1 Manufactured No

202 Each 2.0000 1 1

D4440-1

**

SB 12/6/31

Grommet

Location	Loc Qty	Loc Code
prelim	2	
74759	2	

B 77917

①

AN525-832R6

Purchased No

180 Each 44.0000 3 3

AN525-832R6

**

SB 12/6/31

Screw

Location	Loc Qty	Loc Code
ST345	20	
120308	20	
ST346	24	
118612	24	

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Wednesday, January 25, 2012 11:50:07 AM

Work Order ID: 79377

79377

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-2 Purchased No

180 Each 18,319.00 12 12

MS20426AD3-2

**

Rivet

Location	Loc Qty	Loc Code
Mezz	18319	
1173	8919	
13276	9400	

MS20426AD3-3 Purchased No

180 Each 3,315.000 2 2

MS20426AD3-3

**

Rivet

Location	Loc Qty	Loc Code
ST316	3315	
119109	2812	
19099	503	

MS20470AD4-3 Purchased No

180 Each 5,950.000 5 5

MS20470AD4-3

**

Rivet - Universal Head

Location	Loc Qty	Loc Code
Mezz	5950	
1642	1316	
2193	4634	

MS21075L08 Purchased No

180 Each 78.0000 7 7

MS21075L08

**

ANCHOR NUT

Location	Loc Qty	Loc Code
ST303	3	
111578	3	
ST304	75	
120121	75	

14

12/01/30

12/01/30

12/01/30

Wednesday, January 25, 2012 11:50:07 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-01-29		Change all MS20426 4103-2 to 3-3 Permanent Change 119009		12-01-29	1			
		NO PERMANENT CHG. RIVET LENGTH WAS APPROPRIATE W PREVIOUS MANUFACTURING RUNS. 12.02.06						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD		Work Order: 79377
Description: FWD TANKARD BLACK		Part Number: D4434-073
Inspection Dwg: D4434-1		Rev: A
Page 1 of 1		

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
0.00	1.004 - .001		1.002			V	BAI
0.177	1.005 - .001		1.007			V	
4.48	4.10		4.62			V	
0.34	0.00		0.34			V	
2.00	0.00		2.00			V	
2.47	0.00		2.458			V	
21.80	0.00		21.80			T BAI	
22.30	0.00		22.20			T	
1.67	0.00		1.68			V	
3.88	0.00		3.882			V	
10.62	0.00		10.62			T	
1.40	0.00		1.37			V	

Measured by: B	Date: 12-1-20	Audited by: S	Date: 12/1/20	Prototype Approval:	Date:
----------------	---------------	---------------	---------------	---------------------	-------

Rev	Date	Change	Revised by	Approved
A		New Issue	KJLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

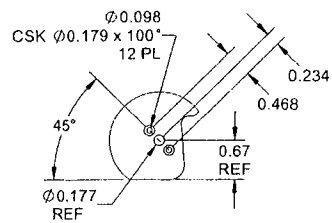
A

D

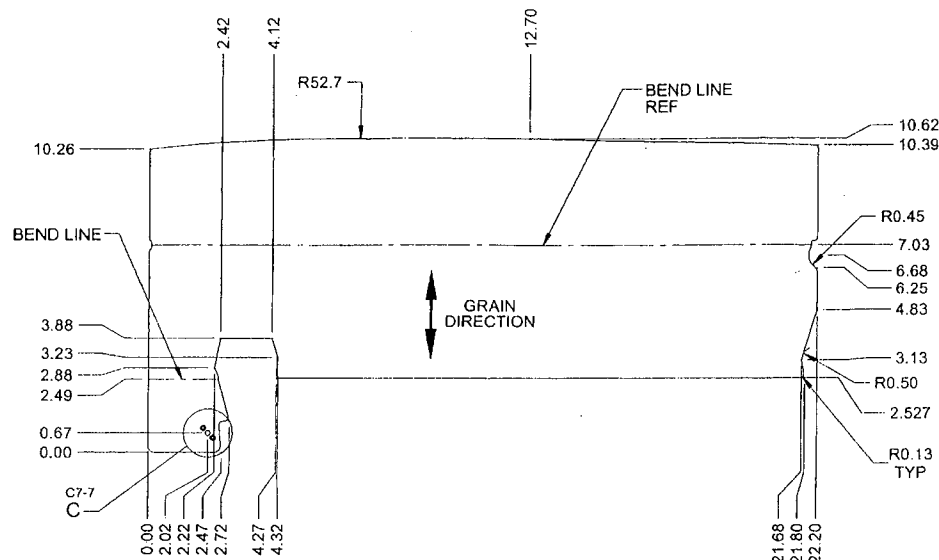
C

B

A



DETAIL C B6-7
SCALE 2X



D4434-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

79377
PL 12-01-29

RELEASED
2012-01-23
MD

DESIGN	RF	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4434	REV. A
MFG. APPR.	RF		SHEET 7 OF 15
APPROVED	RF	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.01.17		

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

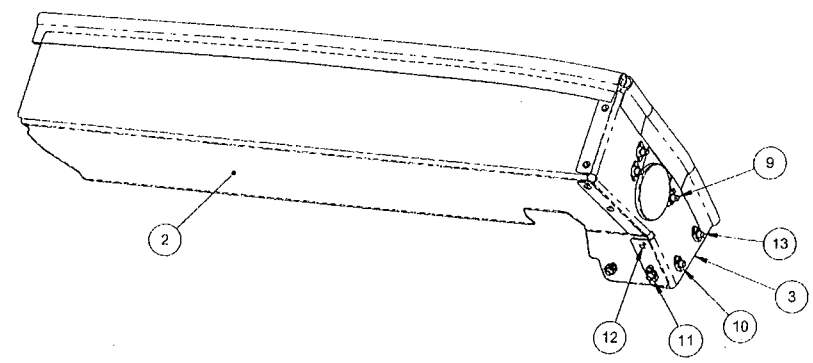
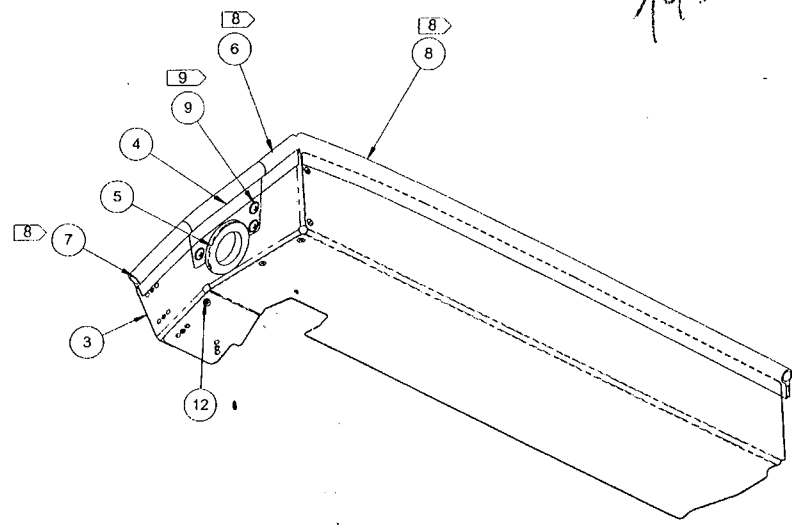
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

19377







ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	O4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-832R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE

D4434-043 FWD INBOARD BRACKET ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) MASK NUT PLATE HOLES
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: N/A
 - 8) WEIGHT: 1.04 lbs
 - 9) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
 - 10) ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
 - 11) IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
 - 12) TORQUE SCREW TO 12-15 (in-lb)

RELEASED
2012-01-23

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4434	SHEET 2 OF 15
APPROVED		TITLE	SCALE
DE APPR.		COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Dart Aerospace Ltd

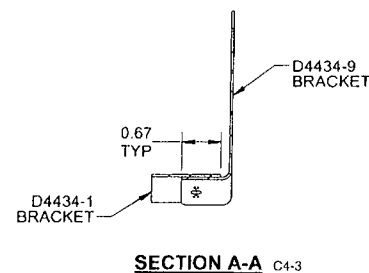
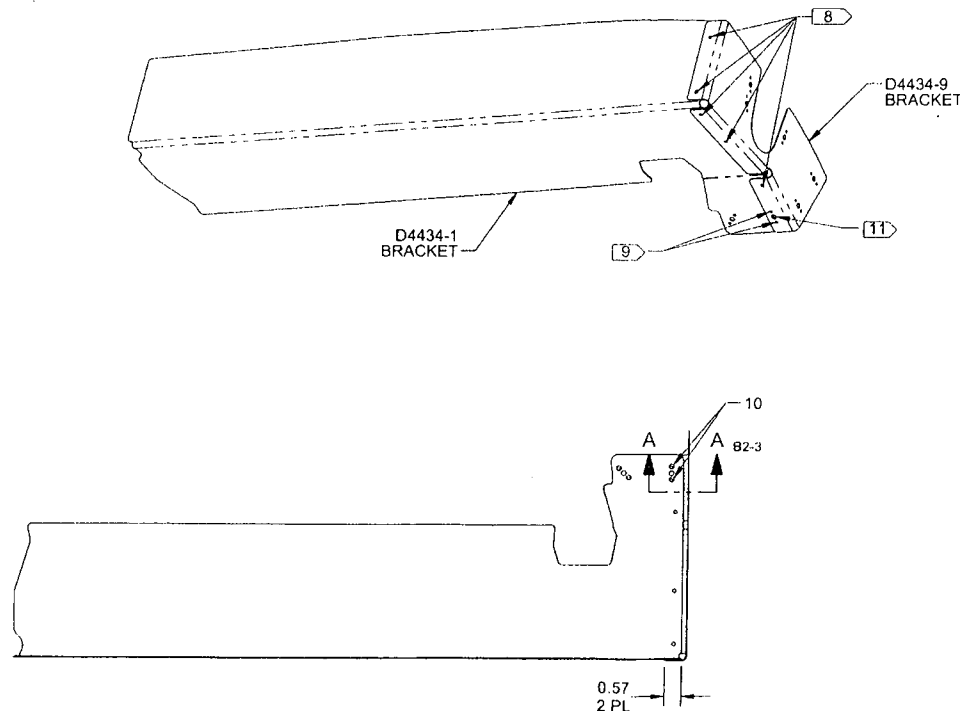
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4434-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.04 lbs
- 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 11) TRANSFER $\phi 0.177$ HOLE THRU FROM D4434-9 TO D4434-1

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4434	REV. A
MFG. APPR.	RF		SHEET 3 OF 15
APPROVED	RF	TITLE COVER ASSEMBLY	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	12.01.17		

RELEASED
2012-01-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

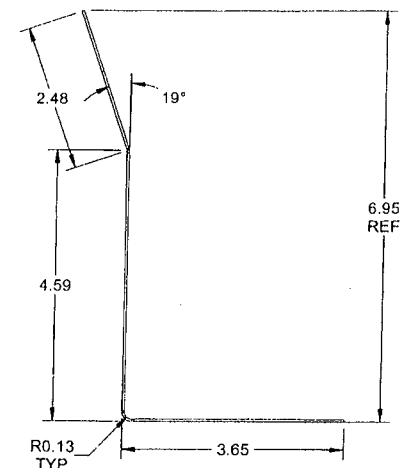
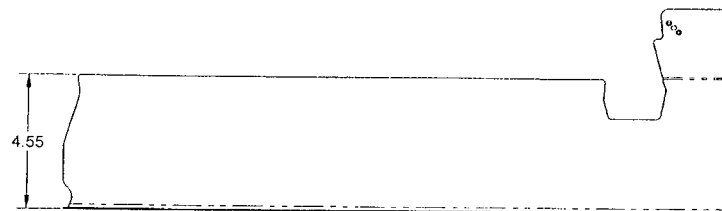
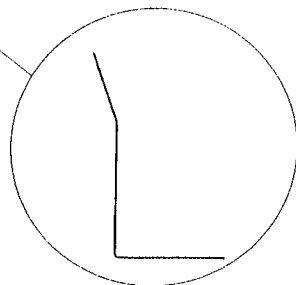
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

19377

B
B2.6



D4434-1 BRACKET

DETAIL B C8-6
SCALE 2X

NOTES:

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

RELEASED
2012-01-23
JWP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4434	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 15	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.01.17	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries